

# Work Order ID 84480

**\*84480\***

Page 1

May-15-12 1:06:14 PM

Item ID: D206-642-412

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 5/14/12 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/14/12 Req'd Qty: 1.00

**\*1\***

Customer:

Reference: rework - ECN09-531

Approvals: Process Plan: *[Signature]*

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
IIN-D206-642	O								
100	DOCUMENT CONTROL <i>[Signature]</i>	0.00							
<b>*100*</b>									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D206-642-412 CHG006 <i>S. 7/16/12</i>								

*[Signature] for MLJ 12-6-11*

**Work Order ID 84480****\*84480\***

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Item ID: D206-642-412

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 5/14/12 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/14/12 Req'd Qty: 1.00

**\*1\***

Customer:

Reference: rework - ECN09-531

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

101

0.00

**\*101\***

HandFinish

Hand Finishing

**Memo**

PULL FROM HK:

1 X D206-642-411 B34562

UPDATE TO CHG006 PER ECN08-538 &amp; 09-531 DSI9421/9440

**REMOVE WEARPLATES:**

6 X D2648-3 B33059

1 X D2656-15 B32579

1 X D2656-23 B32580

1 X D2656-37 B33217

1 X D3429-1 B30237

RETURN TO STK

DISCARD HARDWARE

**ADD:**

6 X D3537-1 B \_\_\_\_\_

1 X D3537-3 B \_\_\_\_\_

1 X D3535-15 B \_\_\_\_\_

1 X D3536-15 B \_\_\_\_\_

1 X D3535-23 B \_\_\_\_\_

1 X D3536-23 B \_\_\_\_\_

1 X D3535-37 B \_\_\_\_\_

1 X D3536-37 B \_\_\_\_\_

60 X MS27039C1-08 B \_\_\_\_\_

60 X AN960C10L (NAS1149C0332R)

B \_\_\_\_\_

<b>DART</b>				TEL.: 1-613-632-3336	
TRANSPORT CANADA APPROVAL # 09-89				FAX: 1-613-632-4443	
P/N	D206-642-412	CHG	CHG004	STC	SH98-4
DESC	Skidtube RH High	STC	SA00475SE	STC	
LOT	B34562	STC		STC	
MODEL	Bell 206L/L1/L3/L4	STC		STC	
US PATENT # 5735484				MADE IN CANADA	
CANADA FOREIGN PATENTS PENDING					

1 / 0 BL 1265

**\*84480\***

May-15-12 1:06:14 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 5/14/12      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date:** 5/14/12      **Req'd Qty:** 1.00      **\*1\***

**Customer:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

### Operation Description

### Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

QC5- Inspect part completeness to step on W/O

0.00

**\*105\***

0.00 Enriches

0.00

QC

**Memo.**

## Quality Control

# Work Order ID 84480

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Item ID: D206-642-412 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Skidtube RH  
 Start Date: 5/14/12 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 5/14/12 Req'd Qty: 1.00 \*1\* Customer:  
 Reference: rework - ECN09-531

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Pick Kit	0.00							

\*110\*

Packaging

Packaging

## Memo

REMOVE FROM KIT TO UPDATE TO CHG006:

1 X D2707-043(OR D2968-043)-SCRAP

1 X AN960JD1016 B

1 X AN970-4 B

1 X MS210424 B

1 X AN4-5A B

1 X AN960JD416 B

1 X D2655 B

RETURN TO STK

## ADD TO KIT:

1 X D3407-043 B

1 X D3456-1 B

2 X D3457-1 B

1 X MS21043-4 B

1 X AN4C5A B

1 X AN960C416 B

1 X D3413-1 B

B30275

12/6/12



# Work Order ID 84480

**\*84480\***

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Item ID: D206-642-412

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 5/14/12 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/14/12 Req'd Qty: 1.00

**\*1\***

Customer:

Reference: rework - ECN09-531

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
130	Packaging	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging	REPACKAGE USING NEW B/N NEW LABELS AND PAPERWORK REQ'D Identify and pack for shipping as per PPP D206-642-412 Location: <u>82</u> PPP Rev: <u>E</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

*P* *12/6/22*

*12/6/22*  
*MF 12-06-21*

# Picklist Print

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Page 1

Work Order ID: 84480

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:K05.10.11 Revised picklist per CHG004KJ/CP/JLM  
IPP Rev:L 07-12-05 ECN 1080p DD verified by:ec  
IPP Rev:M 08-09-29 as per DSI9421 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-5A Bolt		Purchased	No				Each	974.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST355		974							
				120562		974							
AN4C5A BOLT		Purchased	No				Each	199.0000		1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST355		199							
				112243		139							
				119017		60							
AN960C416 washer	NAS1149C0463R	Purchased	No				Each	0.0000		1			
AN960JD1016 Washer	NAS1149C1063R	Purchased	No				Each	369.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		369							
				5519		369							
AN960JD416 Washer	NAS1149D0463J	Purchased	No				Each	30.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		30							
				116289		10							
				119097		20							

D2968-043 B30275

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Work Order ID: 84480

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

AN970-4 Purchased No Each 203.0000

-1

*M104885*

Location	Loc Qty	Loc Code
ST344	203	
115936	11	
120308	3	
120644	30	
121285	159	

D206-642-412 Manufactured No Each 2.0000

1

*B84480*

Location	Loc Qty	Loc Code
FG081	1	
78487	1	
FG082	1	
41319	1	

D2648-3 Manufactured No Each 9.0000

-6

*BR 12-6-5*

Location	Loc Qty	Loc Code
ST <i>33059</i>	-10	
81513	9	
ST237A	19	

D2655 Ring Manufactured No Each 30.0000

\*

*B32988 12/6/12*

Location	Loc Qty	Loc Code
ST464	30	
44295	15	
45738	15	

# Picklist Print

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Work Order ID: 84480  
Parent Item: D206-642-412  
Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D2656-15 Manufactured No Each 6.0000  
Wearshoe

-1 BL 12-6-5-

Location	Loc Qty	Loc Code
FP 32579	5	
83601	5	
Mezz	1	
51455	1	

1  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

D2656-23 Manufactured No Each 9.0000  
Wearshoe

-1 BL 12-6-5.

Location	Loc Qty	Loc Code
Mezz 32580	9	
43407	2	
51468	7	

1  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

D2656-37 Manufactured No Each 21.0000  
Wearshoe

-1 BL 12-6-5.

Location	Loc Qty	Loc Code
Mezz 33217	21	
34510	2	
44550	7	
46497	1	
53019	11	

1  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

D3407-043 Manufactured No Each 14.0000  
Tow Ring

B 833 25 5 1 1

Location	Loc Qty	Loc Code
ST420	1	
79232	1	
ST463	13	
68339	2	
77504	10	
78841	1	

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

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Shop Packet Print

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# Picklist Print

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Work Order ID: 84480  
Parent Item: D206-642-412  
Parent Item Name: Skidtube RH

Start Date: 5/14/12 Required Date: 5/14/12  
Start Qty: 1.00 Required Qty: 1.00

D3413-1 Ring Manufactured No Each 73.0000

Location	Loc Qty	Loc Code
ST420	4	
79233	4	
ST464	69	
76754	1	
80224	7	
83307	41	
83867	20	

D3429-1 Wearpad Manufactured No Each 16.0000

Location	Loc Qty	Loc Code
FP002 30237	16	
40438	2	
43706	1	
44579	12	
65692	1	

D3456-1 Washer Manufactured No Each 168.0000

Location	Loc Qty	Loc Code
FG	7	
25701	7	
ST044	161	
80252	1	
81876	60	
83584	100	

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# Picklist Print

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Work Order ID: 84480  
Parent Item: D206-642-412  
Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D3457-1 Manufactured No Each 35.0000  
Washer

Location	Loc Qty	Loc Code
FG	10	
32409	10	
ST044	25	
67779	1	
81977	24	

B83263 1

D3535-15 Manufactured No Each 17.0000  
Wearshoe

Location	Loc Qty	Loc Code
FP001	17	
80328	4	
81354	13	

1 BR 12-6-5

D3535-23 Manufactured No Each 22.0000  
Wearshoe

Location	Loc Qty	Loc Code
FP001	22	
81355	2	
83375	20	

1 BR 12-6-5

D3535-37 Manufactured No Each 4.0000  
Wearshoe

Location	Loc Qty	Loc Code
FP001	4	
71668	4	

1 BR 12-6-5

D3536-15 Manufactured No Each 20.0000  
Gasket

Location	Loc Qty	Loc Code
FP002	20	
73318	14	
81343	6	

1 BR 12-6-5

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Shop Packet Print

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# Picklist Print

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Work Order ID: 84480

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D3536-23 Manufactured No Each 16.0000

Gasket

1 BL 12-65

Location	Loc Qty	Loc Code
FP002	16	
74510	1	
83377 ✓	15	

D3536-37 Manufactured No Each 19.0000

Gasket

1 BL 12-65

Location	Loc Qty	Loc Code
FP002	19	
66823	7	
82623 ✓	12	

D3537-1 Manufactured No Each 41.0000

Wearpad

6 BL 12-65

Location	Loc Qty	Loc Code
FG	10	
79833	10	
FP002	31	
69817	5	
81362	22	
83254	1	
83255	3	

D3537-3 Manufactured No Each 28.0000

Wearpad

1 BL 12-65

Location	Loc Qty	Loc Code
FP002	28	
78836	5	
81363 ✓	23	

# Picklist Print

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Work Order ID: 84480  
Parent Item: D206-642-412  
Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

MS21042-4  
USE MS21042L4

Purchased No

Each 1,071.0000

-1

M1046839

Location	Loc Qty	Loc Code
ST299	1071	
100743	9	
119124	1000	
5461	1	
6844	19	
7690	24	
8182	6	
9063	8	
9229	4	

MS21043-4  
Nut

Purchased No

Each 1,546.0000

1

12/6/12

Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST301	1506	
119546	185	
121162	821	
121652	500	

MS27039C1-08  
SCREW

Purchased No

Each 1,142.0000

60

BR 12-6-5.

Location	Loc Qty	Loc Code
FP002	1	
116022	1	
ST292	1122	
120308	354	
121068	108	
121162✓	660	
ST293	19	
116373	3	
118077	14	
119309	2	

60.

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# Picklist Print

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Work Order ID: 84480

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

Each 3,354.0000

60

BRD-65

Washer

Location

Loc Qty

Loc Code

ST297

219

119736

196

120648

23

ST298

3135

121255

11

121509 ✓

3124

60.

May-15-12 1:06:14 PM

Shop Packet Print

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412

40

Date: Wednesday, 9/12/2007 11:51:46 AM  
User: Kim Johnston









# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 34562A  
Estimate Number : 10522  
P.O. Number :  
This Issue : 9/12/2007 S.O. No. :  
Prsht Rev. : NC  
First Issue : / / Type : LANDING GEAR  
Previous Run : 34561A  
Written By :  
Checked & Approved By :  
Comment : Est Rev: H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JL  
M

Drawing Name : 206 L HIGH GEAR SKIDTUBE  
Part Number : D206642441  
Drawing Number : D2650 REV E  
Project Number : N/A  
Drawing Revision : E  
Material :  
Due Date : 10/5/2007 Qty: 1 Um: Each

## Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
		 
	Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D206-642-441 CHG002 N/A KJ	
2.0	D2620	Bent 206 Skidtube
		 
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2620 Bent Tube 3" OD B33880 07/09/17 AWM	
3.0	D2647	Cap
		 
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2647 Fwd Cap B29328 BE 07-10-02	
4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
		 
	Comment: LANDING GEAR RESOURCE 1  1-Deburr Fwd edge of tube  2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650  3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. A/R Aluminum Rod M105136 BE 07-10-02  4-Grind weld flush to cap on top surface only. BE 07-10-02	

Date: Wednesday, 9/12/2007 11:51:46 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34562A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

DP  
7-10-4

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DP  
7-10-4

6.0

D26547

206 I Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-7

Web

1034594

DP  
7-10-5

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting

Start Date: 7-10-5 Time: 8 am

Finish Date: 7-10-7 Time: 8 AM

A/R Sikaflex-291 M105586

Sikaflex expiry date: 8-7-1

DP  
7-10-5  
7-10-4  
DP

Date: Wednesday, 9/12/2007 11:51:47 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34562A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/10/09

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total: 23.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

23 D2649

Crossbolt spacer

B-34612

BE

07/10/09

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod

M105138

BE 07/10/09

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Debur

) 7-10-9

11.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2680-041

Nut Plate

B30946

Q

7-10-9

12.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 CCR264SS3-3

Rivets

M105525

Q

7-10-9

13.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch



Date: Wednesday, 9/12/2007 11:51:47 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR-SKIDTUBE

Job Number: 34562A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

2 M7885/3-4-3

Rivets

M102515 ② R 7-10-9

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

R 7-10-9

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

② 07-10-10

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

E 07/10/10

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

HJ 07-10-11

①

18.0

POWDER COATING

POWDER COATING



M105068



(1X)

Comment: POWDER COATING

Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3

Make sure Nut Plate Thread protected use paint screw

M.K 07/10/11

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 07-10-11

20.0

D26483

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

B33059

BR

21.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-15

Wearshoe

B32579

BR

BR 07-10-12

Form: process

Date: Wednesday, 9/12/2007 11:51:47 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34562A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D265623

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe

B32580

BR

23.0

D265637

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-37

Wearshoe

B33217

BR

24.0

D34291

\*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad

B30237

BR

25.0

ALS41032130

Insert



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 ALS4-1032-130

Inserts

M105855

or (see QSI 017)

\*

BR

26.0

AN960JD10L

Washer



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 AN960JD10L

Washer

M104885

BR

BR 07-10-12

Date: Wednesday, 9/12/2007 11:51:47 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34562A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

MS27039108

Screw



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 MS27039-1-08

Screw

*BR*  
*105433*

28.0

D26511

Plug



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-1

Plugs

*BR*  
*B33185*

29.0

D26513

O-Ring



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-3

O-Rings

*BR*  
*B33452*

30.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer

*BR*  
*M103338*

31.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS27039-4-06

Screw

*BR*  
*M15194*

32.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

*BR*  
*B33289*

Date: Wednesday, 9/12/2007 11:51:47 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34562A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

1 D2646

Aft Cap

33.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN960JD10L

Washer

M 104885

BR

34.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 MS27039-1-08

Screw

M 105433

BR

35.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

Sikaflex expiry date:

M 105469  
08-01

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650.  
Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291

Sikaflex expiry date:

M 105469  
08-01

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch:

M 105694

FL

02/10/12 ①

BR 07-10-12

Part Number D206-642-412  
Description 206 SKIDSTEER INSTALLATION

Page 1 of 1

[illegible]

**ENGINEERING CHANGE NOTICE**  
**DART AEROSPACE LTD**

Date: 09.02.18	Job No.: 00569	ADR Yes/No: N	ADR Date:	ECN #: 09- 531
Product No.: D206-642	Created By: AJS	Approved By: <i>[Signature]</i>		
Product Name: Skidbe Installation	Checked By: <i>[Signature]</i>	General Manager Approval:		

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	<i>LL 09/02/19</i>
Production Engineering Coord	Y	EC/DD	<i>EC 09/02/19</i>
Production Document Control	Y	JLD	<i>JLD 09.02.19</i>
Customer Technical Support			

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord			
QC Coordinator	Y	JM	<i>JM 09.02.19</i>
Marketing	Y	SW	<i>SW 09.03.19</i>
Customer Order Processing			

**Reason for Change:** DESIGN IMPROVEMENT CHANGE FROM CARBON STEEL TO STAINLESS STEEL

**Documents Affected:**

DSI 9421 REV B  
DSI 9440 REV A  
D206-648 REV B  
D3414 Rev B

**PARTS MUST COMPLY**

☐

**PREVIOUS PARTS SATISFACTORY**

☒

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	Y	KJ		<i>09.02.19</i>
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		<i>09.02.19</i>
9	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		<i>09.02.19</i>
10	Update Controlled PDF Files	Y	KJ		<i>09.02.19</i>
11	Update Master Document List (MDL)	Y	AJS	<i>Rev. U</i>	<i>09.02.19</i>
12	Update Document Record (DR)	Y	KJ		<i>09.02.19</i>
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N			
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	Y	KJ	<i>SEE BELOW</i>	<i>09.02.19</i>
18	Create / Update PPP's	Y	KJ		<i>09.02.19</i>
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	Y	KJ		<i>09.02.19</i>
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		<i>09.02.19</i>
22					
23					

**Description / Action:**

Roll -111/-112/-211/-212/-213/-214 to Change number 005 (Per DSI 9421)

*-141/-241 @ CHG 004, -143/-243 @ CHG 002 (PER DSI 9440 Rev. A)*

Roll -311/-312/-411/-412 To Change number 006 (Per DSI 9421)

*-341/-441 @ CHG 003, -443 @ CHG 001, 343 @ CHG 002 (PER DSI 9440 Rev. A)*

Previous parts Disposition: Deplete existing stock of -111/-112/-211/-212/-213/-214 parts @ Change 004 repectively. DO NOT mix parts from change 004 and change 005

Previous parts Disposition: Deplete existing stock of -311/-312/-411/-412 parts @ Change 005 DO NOT mix parts from change 005 and change 006

*D206-648-011/-013 NOW AT CHG002 (D206-648 Rev. B) -DO NOT MIX PARTS*

ECN Verified & Complete: *[Signature]*

Date: *09/03/16*

# **ENGINEERING CHANGE NOTICE** **DART AEROSPACE LTD**

Date: 09.02.18	Job No: 00569	ADR Yes/No: N	ADR Date:	ECN #: 09- 531
Product No.: D206-642	Created By: AJS	Approved By: [Signature]		
Product Name: Skidbte Installation	Checked By: [Signature]	General Manager Approval:		

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	
Production Engineering Coord	Y	EC/DD	09/02/19
Production Document Control	Y	JLD	09.02.19
Customer Technical Support			

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord			
QC Coordinator	Y	JM	09.02.19
Marketing	Y	SW	
Customer Order Processing			

Reason for Change: DESIGN IMPROVEMENT CHANGE FROM CARBON STEEL TO STAINLESS STEEL

**Documents Affected:**

DSI 9421 REV B  
DSI 9440 REV A  
D206-648 REV B  
D3414 Rev B

**PARTS MUST COMPLY**

☐

**PREVIOUS PARTS SATISFACTORY**

☒

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	Y	KJ		09.02.19
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		09.02.19
9	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		09.02.19
10	Update Controlled PDF Files	Y	KJ		09.02.19
11	Update Master Document List (MDL)	Y	AJS	Rev. U	09.02.19
12	Update Document Record (DR)	Y	KJ		09.02.19
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N			
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	Y	KJ	SEE BELOW	09.02.19
18	Create / Update PPP's	Y	KJ		09.02.19
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	Y	KJ		09.02.19
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		09.02.19
22					
23					

**Description / Action:**

Roll -111/-112/-211/-212/-213/-214 to Change number 005 (Per DSI 9421)

-141/-241 @ CHG 004, -143/-243 @ CHG 002 (PER DSI 9440 Rev. A)

Roll -311/-312/-411/-412 To Change number 006 (Per DSI 9421)

-341/-441 @ CHG 003, -443 @ CHG 001, 343 @ CHG 002 (PER DSI 9440 Rev. A)

Previous parts Disposition: Depelete existing stock of -111/-112/-211/-212/-213/-214/parts @ Change 004 repectively. DO NOT mix parts from change 004 and change 005

Previous parts Disposition: Depelete existing stock of -311/-312/-411/-412 parts @ Change 005 DO NOT mix parts from change 005 and change 006

D206-648-011/-013 NOW AT CHG002 (D206-648 Rev. B) -DO NOT MIX PARTS

N/A  
JW 09.03.03

ECN Verified & Complete: \_\_\_\_\_

Date: \_\_\_\_\_

4.4 206L/L-1/L-3/L-4 High Gear Skidtubes (D206-642)  
32.13 206L/L-1/L-3/L-4 High Gear Skidtubes (ICA-D206-642)

IS:

ITEM	Qty -411	Qty -412	Qty -441	Qty -443	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-443	WEARSHOE KIT
	1	1			X	D206-648-013	GROUND HANDLING KIT
30	1	1				D3407-043	TOW RING ASSEMBLY
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING
40					2	D3414-041	LUG ASSEMBLY
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

WAS:

ITEM	Qty -411	Qty -412	Qty -441	Qty -443	Qty -011	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-443	WEARSHOE KIT
	1	1			X	D206-648-011	GROUND HANDLING KIT
30	1	1				D2707-043 (OR D2968-043)	TOW RING
31	1	1				AN960JD1016	WASHER
32	1	1				AN970-4	WASHER
33	1	1				MS21042-4	NUT (OR MS21042L4)
34	1	1				AN4-5A	BOLT
35	1	1				AN960JD416	WASHER
36	1	1				D2655	RING
40					2	D2659	GHW LUG
41					4	AN3-37A	BOLT
42					8	D2652	BUSHING
43					4	MS21042-3	NUT (OR MS21042L3)
44					4	AN960DJ10	WASHER

DESIGN	AJS	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA
DRAWN	AJS	
CHECKED		DRAWING NO. REV. B
MFG. APPR.	N/A	DSI 9421 SHEET 4 OF 5
APPROVED		TITLE SCALE
DE APPR.		SKIDTUBE INSTALLATIONS NTS
DATE	08.10.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC



4.3 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skidtubes (D206-642)  
32.12 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skidtubes (ICA-D206-642)

ITEM	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)	(MODIFY)
22B			1	1		D3536-11	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)	(MODIFY)
24B			1	1		D3536-35	GASKET	(ADD)
26A			54			MS27039-1C08	SCREW	(MODIFY)
26B			54			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-11	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-35	WEARSHOE
26A			54			MS27039-1-08	SCREW
26B			54			AN960JD10L	WASHER

4.4 206L/L-1/L-3/L-4 High Gear Skidtubes (D206-642)  
32.13 206L/L-1/L-3/L-4 High Gear Skidtubes (ICA-D206-642)

ITEM	Qty -411	Qty -412	Qty -441	Qty -447	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-447	WEARSHOE KIT (REPLACES -443)
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-15	WEARSHOE (REPLACES D2656-15)	(MODIFY)
22B			1	1		D3536-15	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-37	WEARSHOE (REPLACES D2656-37)	(MODIFY)
24B			1	1		D3536-37	GASKET	(ADD)
26A			60			MS27039-1C08	SCREW	(MODIFY)
26B			60			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-15	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-37	WEARSHOE
26A			60			MS27039-1-08	SCREW
26B			60			AN960JD10L	WASHER

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<del>NA</del>	DRAWING NO.	REV. 3
MFG. APPR.	N/A	DSI 9440	SHEET 3 OF 4
APPROVED	<del>NA</del>	TITLE	SCALE
DE APPR.	<del>NA</del>	WEARSHOE CHANGE	NTS
DATE	09.03.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

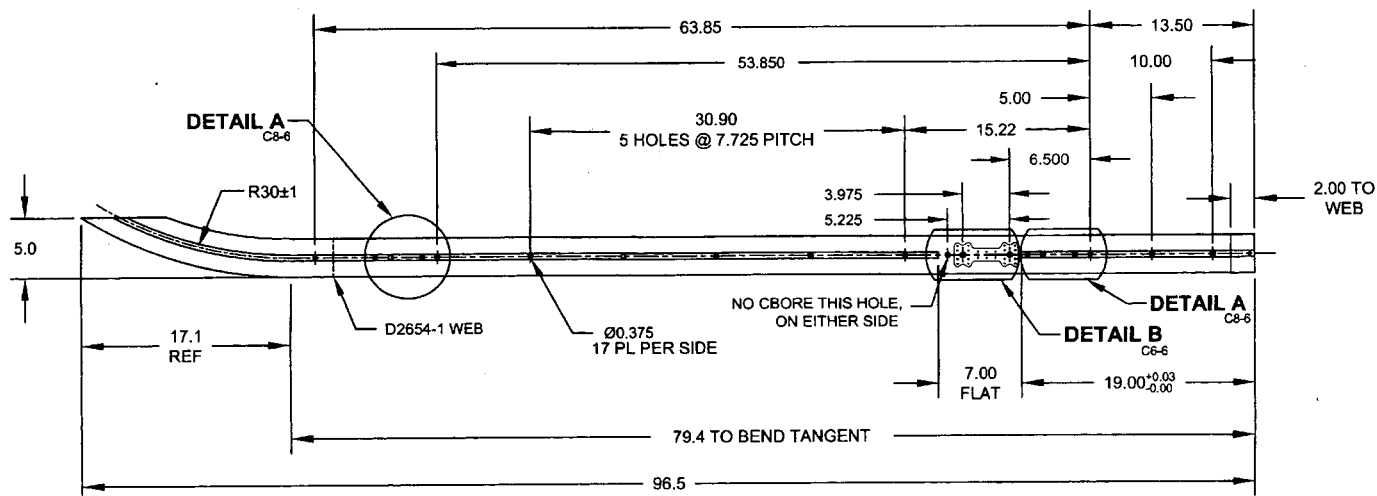
# **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

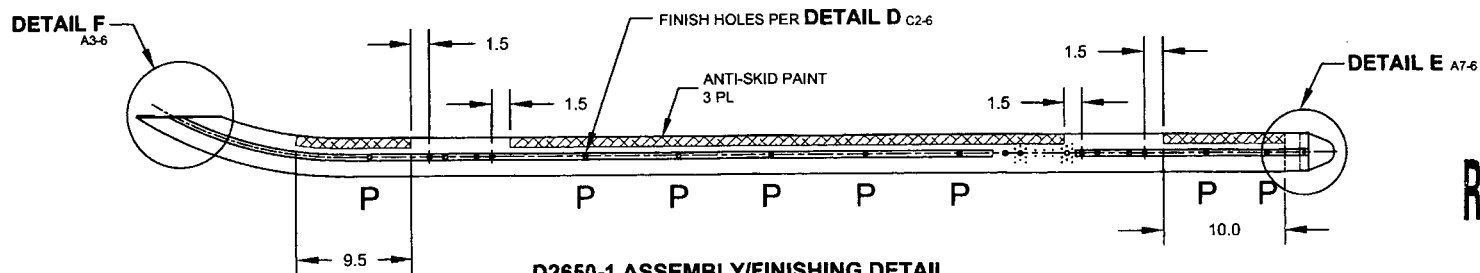
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239)	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
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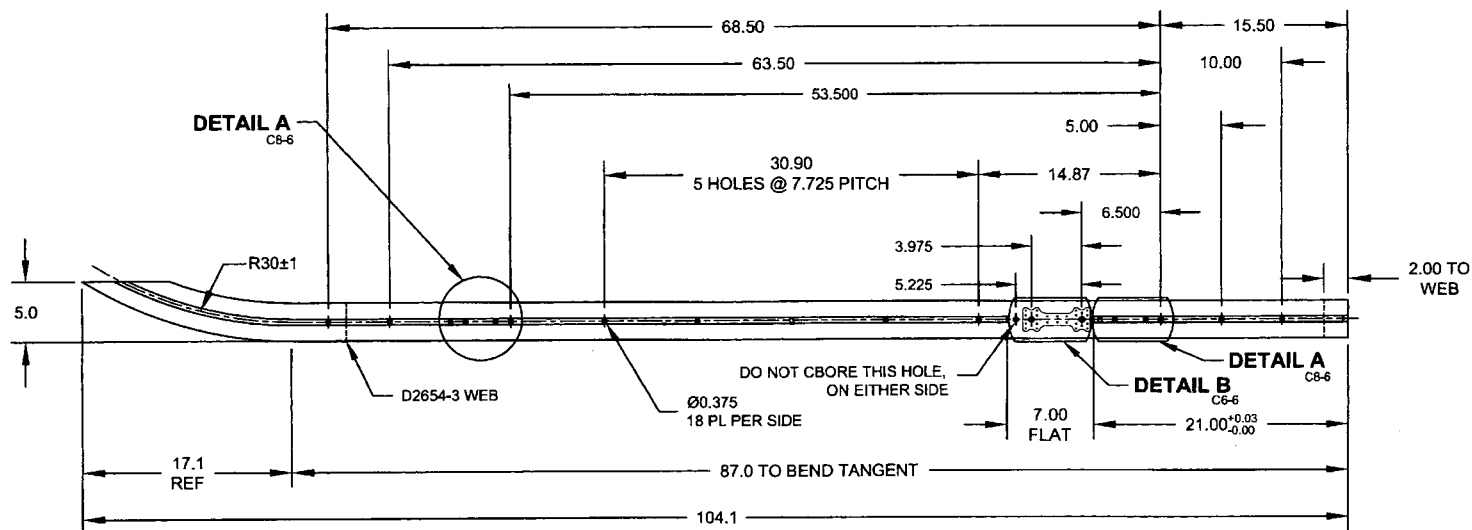
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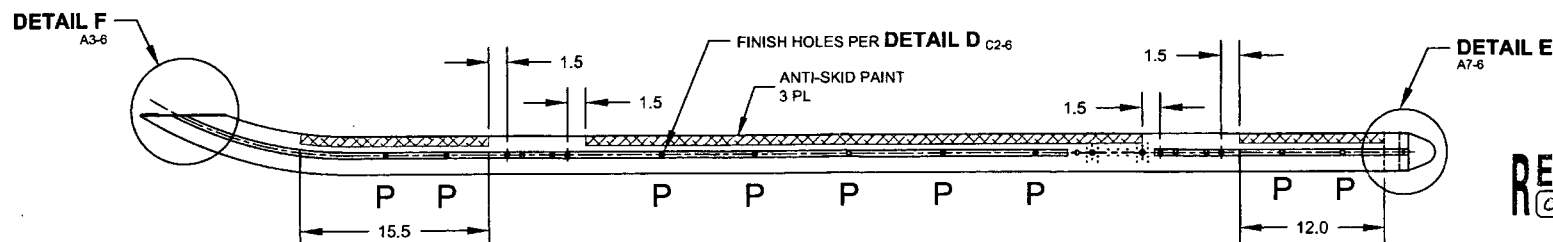
**D2650-1 ASSEMBLY/FINISHING DETAIL**

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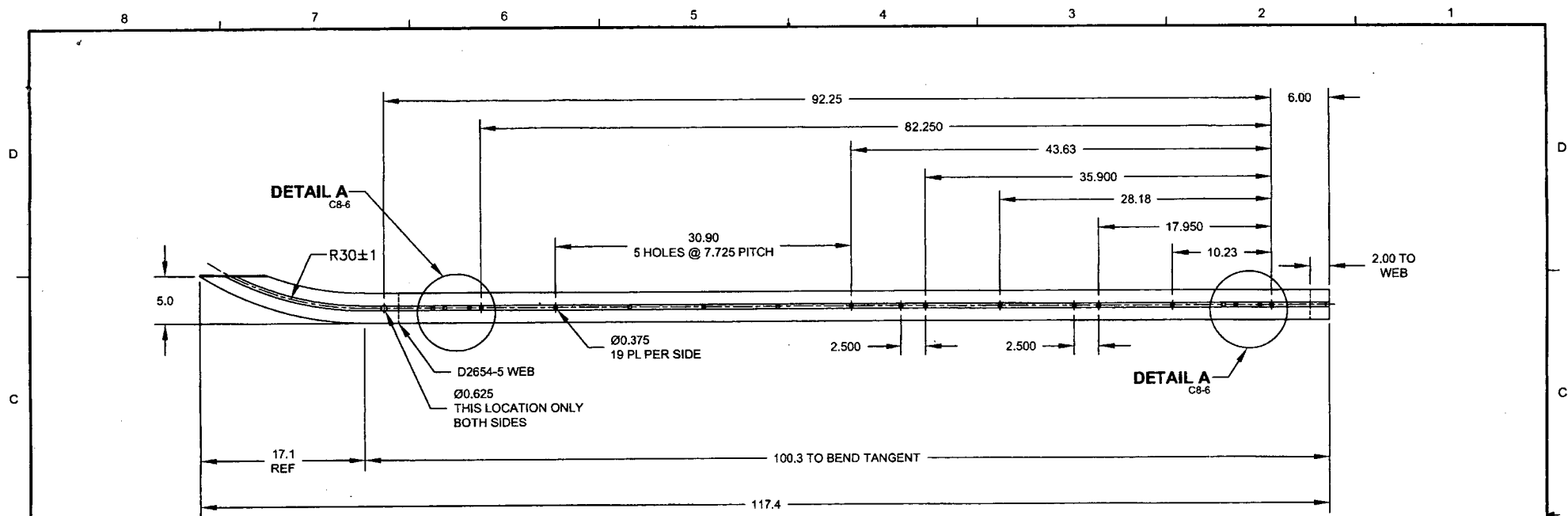
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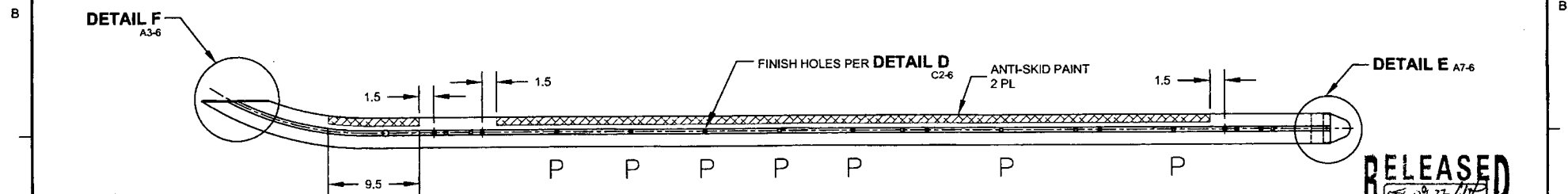
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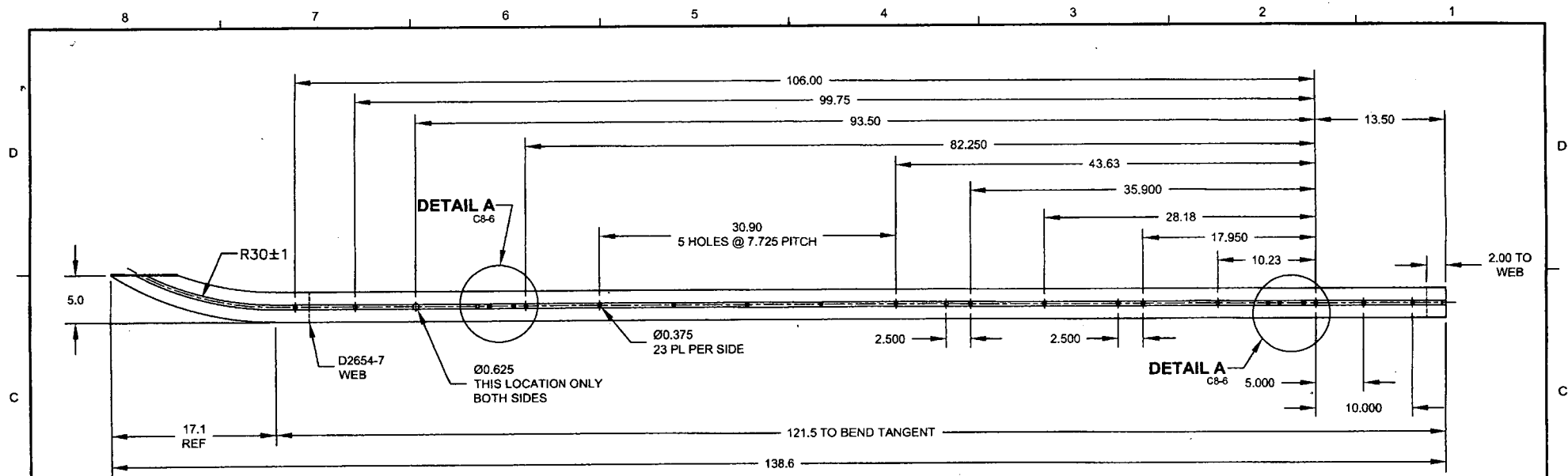


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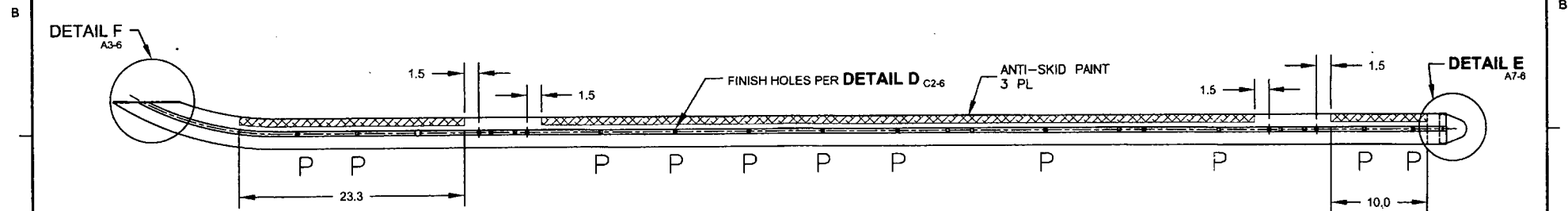
**D2650-5 ASSEMBLY/FINISHING DETAIL**

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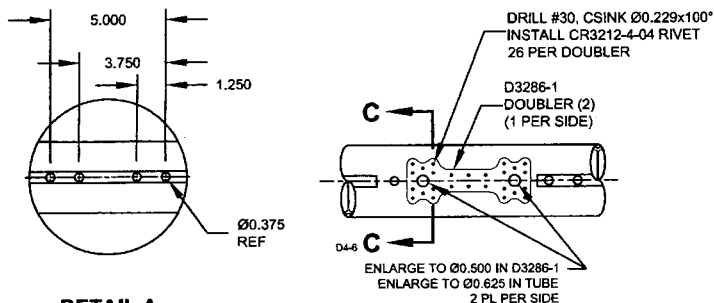
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**D2650-7 ASSEMBLY/FINISHING DETAIL**

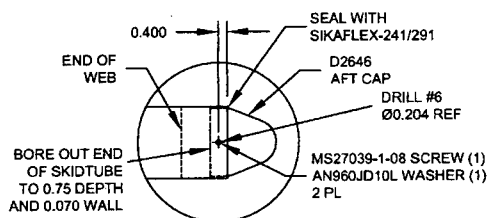
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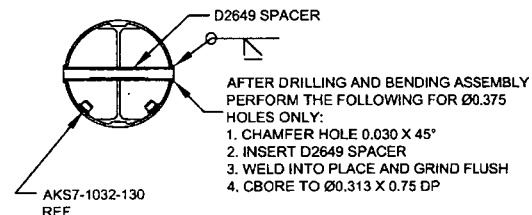
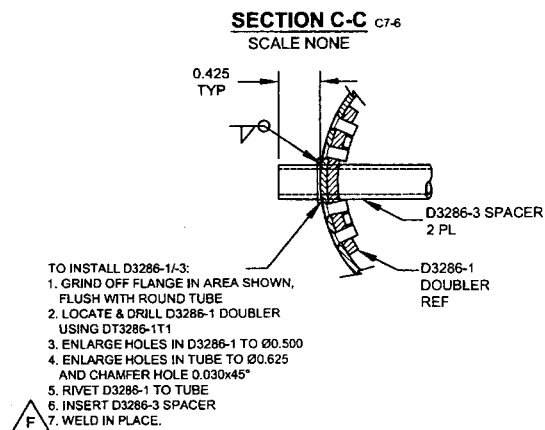
**DETAIL A**  
SCALE 2X  
C2-2  
D7-2  
C2-3  
D7-3  
C2-4  
D7-4  
C2-5  
D6-5

ENLARGE TO Ø0.500 IN D3286-1  
ENLARGE TO Ø0.625 IN TUBE  
2 PL PER SIDE

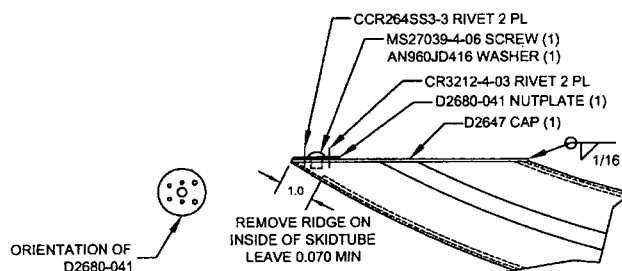
**DETAIL B**  
SCALE 2X  
C3-2  
C3-3



**DETAIL E**  
SCALE 2X  
B2-2  
B2-3  
B1-4  
B1-5






**DETAIL D**  
FOR Ø0.375 HOLES ONLY  
SCALE 3X  
B4-2  
B4-3  
B4-4  
B4-5



**DETAIL F**  
SCALE NONE  
B8-2  
B8-3  
B8-4  
B8-5

- DETAIL F NOTES:**
1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D2647 (TRIM AS NECESSARY)
  4. WELD D2647 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D2680-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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03-09-22-10

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